



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V3008102

Job Sheet 190207



Part No: RBEM632V3008102

Job Qty: 2 pcs

Part Name: Output Flange Seal Exchange



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM632V3008102 Rev. C IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	2/8/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	2 pcs	2/8/19		0.00	2.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MLL
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	2 pcs	2/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S155780



Part: RBEM632V3008102

Job No: 190207

Serial No/Batch: S155780

Revision: C

Inspector:

Exp Date:

Instructions:

Date: 02/22/19

Plex 2/22/19 8:45 AM Dart.Hadley.Shannon

				QC 5 - 30		98 93 94 19/02/21	
130	Packaging 3-1 - Stock - B4B	2 pcs	2/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	MLC
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	2/8/19	0.00	0.00	QC 21 - FG - 21	DAS
						QC 21 - FG - 70	21 FEB 22 2019
						QC 21 - SA - 53	3-55

Part Op **100** - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEM632V3008102-4 to RBEM632V3008102-2 foam as per DWG. 6-Glue foam to case and pack case as per DWG

110 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEM632V3008102-4 to RBEM632V3008102-2 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1450-E	Case	2 Ea (1 ea)	100-Small Fab - 1	
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	110-Small Fab - 2 - B4B	
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	110-Small Fab - 2 - B4B	
RBEM632V3008102-10	Press	2 pcs (1 ea)	110-Small Fab - 2 - B4B	
RBEM632V3008102-2	Top Foam use in case APP-1450-E	2 Ea (1 ea)	110-Small Fab - 2 - B4B	
RBEM632V3008102-3	Bottom Foam use in case APP-1450-E	2 Ea (1 ea)	110-Small Fab - 2 - B4B	
RBEM632V3008102-4	Location Placard	2 pcs (1 ea)	110-Small Fab - 2 - B4B	
RBEM632V3008102-5	Body	2 pcs (1 ea)	110-Small Fab - 2 - B4B	
RBEM632V3008102-6	Support Ring Assembly	2 pcs (1 ea)	110-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1450-E	2	18	0
110-Small Fab - 2 - B4B	97524A032	8	438	0
	RB41011	2	407	0
	RBEM632V3008102-10	2	2	0
	RBEM632V3008102-2	2	2	0
	RBEM632V3008102-3	2	2	0
	RBEM632V3008102-4	2	3	0
	RBEM632V3008102-5	2	5	0
	RBEM632V3008102-6	2	7	0

Part Specifications

Specifications could not be found.

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Part No: RBEM632V3008102

Job Qty: 2 pcs

Part Name: Output Flange Seal Exchange



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 2/8/19 Feb 20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM632V3008102 Rev. C IPP Rev. A 18.06.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	2/8/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		
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							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	2/8/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	2/8/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 110 - Small Fab - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEM632V3008102-4 to RBEM632V3008102-2 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

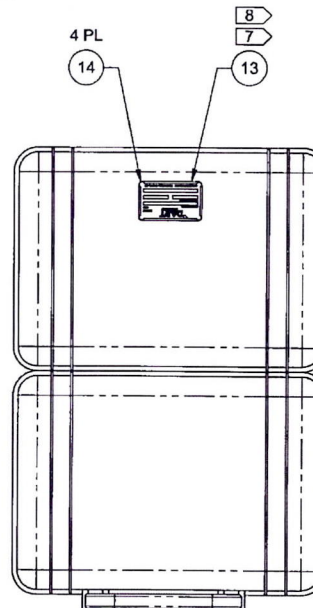
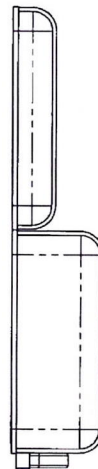
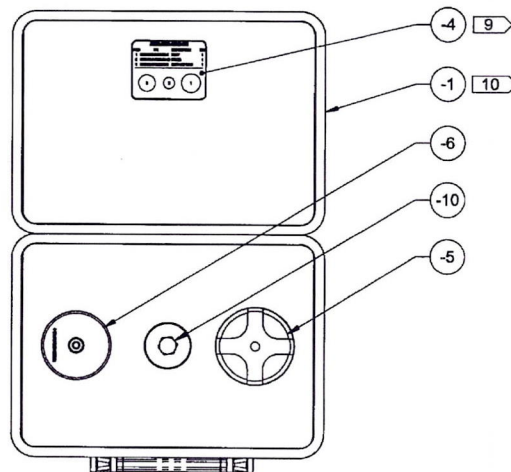
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	110-Small Fab - 1	5113449
APP-1450-E	Case	2 Ea (1 ea)	110-Small Fab - 1	5155577 5
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	110-Small Fab - 1	5021040
RBEM632V3008102-10	Press	2 pcs (1 ea)	110-Small Fab - 1	115155718 115110069
RBEM632V3008102-2	Top Foam 1.79 X 10.47 X 14.89 (Ethafom 220. Black)	2 pcs (1 ea)	110-Small Fab - 1	5155575
RBEM632V3008102-3	Bottom Foam 4.26 X 10.47 X 14.89 (Ethafom 220. Black)	2 pcs (1 ea)	110-Small Fab - 1	5155576
RBEM632V3008102-4	Location Placard	2 pcs (1 ea)	110-Small Fab - 1	51134488 27
RBEM632V3008102-5	Body	2 pcs (1 ea)	110-Small Fab - 1	5099604
RBEM632V3008102-6	Support Ring Assembly	2 pcs (1 ea)	110-Small Fab - 1	5099989

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	8	526	0
	APP-1450-E	2	17	0
	RB41011	2	425	0
	RBEM632V3008102-10	2	1	0
	RBEM632V3008102-2	2	0	0
	RBEM632V3008102-3	2	0	0
	RBEM632V3008102-4	2	1	0
	RBEM632V3008102-5	2	5	0
	RBEM632V3008102-6	2	7	0
Part Specifications				
Specifications could not be found.				

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBEM632V3008102-1	PACKAGING ASSY
-4	1	RBEM632V3008102-4	POSITION PLACARD
-5	1	RBEM632V3008102-5	BODY
-6	1	RBEM632V3008102-6	SUPPORT RING ASSY
-10	1	RBEM632V3008102-10	PRESS
13	1	RB41011	DART PLACARD
14	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RBEM632V3008102 OUTPUT FLANGE SEAL EXCHANGE

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

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WITHOUT NOTICE
WORK ORDER
NO. 190207 MJS
19-02-06

C		TEMPLATE UPDATED, PART NUMBERS CHANGED PER DART'S STANDARD, NOTES ADDED, RIVETS ADDED TO SHEET 1, -1 DRAWING ADDED, -4 MULTICRAFT PLASTICS #LM922402 MATERIAL ADDED, -5 DIMENSION 3.544 +/- 0.001" CHANGED FOR 3.550/3.555, DIMENSIONED PER DART'S STANDARDS, FINISH ZINC PLATE AND POWDER COAT REMOVED, MATERIAL 4140/4142 CHANGED FOR SS 303/304/316, -6 HARDWARE IN STEEL CHANGED FOR SS, -8 DIMENSION 3.540 +/- 0.001" CHANGED FOR 3.545/3.540, ENGRAVING ADDED, NOTES ADDED, DIMENSION M64 x 1.5 - 6H CHANGED FOR M64 x 1.5 - 6H LEFT HAND, MATERIAL, 4140/4142 CHANGED FOR SS 303/304/316-9 McMaster#1078N13 CHANGED FOR McMaster#98863A368, CENTER DRILL NOTE ADDED	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	KPT		
CHECKED	MJS		
MFG. APPR.	DP		
APPROVED	MJS		
DATE	6/6/2018		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	SHEET 1 OF 13
TOOL PART # RBEM632V3008102		SCALE	NTS
TITLE OUTPUT FLANGE SEAL EXCHANGE			
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					